

Work Order ID 137108

137108

Page 1

Thursday, September 24, 2015 2:09:10 PM

Item ID: D3256-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Panel
Start Date: 9/23/15 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 9/23/15 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: SEP 25, 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3256	E

100	FLOW WATER JET	0.00				(3)			02/15/11/03
-----	----------------	------	--	--	--	-----	--	--	-------------

100
Waterjet
FLOW CNC Waterjet
Memo
1-Cut as per Dwg D3256
Dwg Rev: E
Prog Rev: E
2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00				(3)			02/15/11/03
-----	---	------	--	--	--	-----	--	--	-------------

110
QC
Quality Control
Memo

120	QC8- Inspect parts - second check	0.00				(3)			DAS 38 9-89
-----	-----------------------------------	------	--	--	--	-----	--	--	-------------------

120
QC
Quality Control
Memo
NOV 0.3 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 137108

Thursday, September 24, 2015 2:09:10 PM

137108

Page 2

Item ID: D3256-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Panel

Start Date: 9/23/15

Start Qty: 3.00

3

Cust Item ID:

Required Date: 9/23/15

Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

Brake NC

NC BRAKE

Memo

Form using D3256-1T2

0.00

0.02

3

FF

NOV 03 2015

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.02

3

DAS
38
9-89

NOV 03 2015

150

150

Packaging

Packaging

Identify as per dwg & Stock Location: 51489

Memo

0.00

0.00

3

DAS
27
9-89

NOV 04 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
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OTHER : _____							

Work Order ID 137108

137108

Page 3

Thursday, September 24, 2015 2:09:10 PM

Item ID: D3256-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Panel

Start Date: 9/23/15 Start Qty: 3.00 *3*

Cust Item ID:

Required Date: 9/23/15 Req'd Qty: 3.00 *3*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MC

NOV 04 2015

MC

NOV 04 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Picklist Print

Page 1

Thursday, September 24, 2015 2:09:10 PM

Work Order ID: 137108

137108

Parent Item: D3256-1

D3256-1

Parent Item Name: Panel

Start Date: 9/23/15

Required Date: 9/23/15

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A New Issue 07-09-28 EC verified by:DD
IPP Rev:b ECN 1052 07-10-31 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased		No		100	sf	132.8602	0.987	3.116842			

M304S22GA

304/316 .032 Sheet

09/15/11/03

Location

Loc Qty

Loc Code

MAT020

132.8602

m126593

69.8602

m131999

63

3.6

DQA: _____ Date: _____

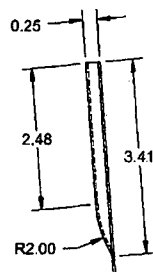


WORK ORDER NON-CONFORMANCE / UPDATE

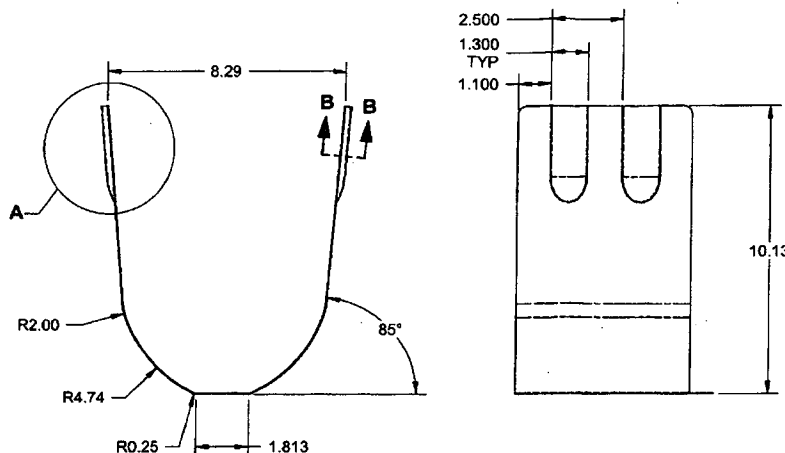
QA Closed: _____ Date: _____

Work Order update only ☐

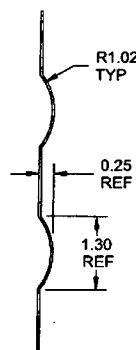
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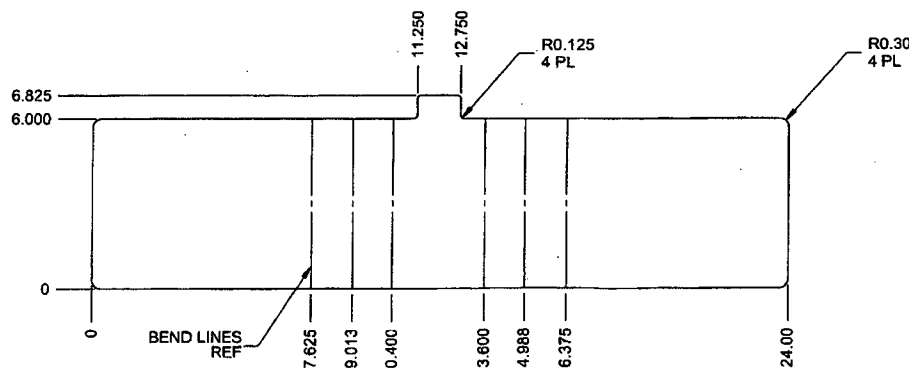
DETAIL A
SCALE 2X



D3256-1 ACCESS PANEL
(MAKE FROM D3256-1F)



SECTION B-B
SCALE 2X
(VIEW ROTATED)



D3256-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 0.032 THICK
PER MIL-S-5019 OR AMS 5513/AMS 5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S22GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3256-1" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 1.37 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 137108 MLJ

RELEASED
2012-11-06

E	CHANGED MATERIAL FOR D3256-3. REASON: PROCUREMENT, REF CAR12-69.	MB	12.10.16
D	UPDATED TO COMPLY WITH QSI 043; REMOVED "FORM JOGGLE PER D3256-1T1" AND "FORM PER D3256-1T2" (SEE PREVIOUS REV FOR REFERENCE); 6.825 WAS 6.450 (ZN B7-1); 0.83 WAS 0.45 (ZN C8-2). REASON: PAR11-124.	MB	11.10.25
C	D3256-041 ELIMINATED; REMOVED (QTY.22) 0.128 HOLES FROM D3256-1F AND D3256-3 GASKET. INSTRUCTIONS TO DRILL HOLES AND INSTALL D3256-3 GASKET ARE NOW PART OF THE INSTALLATION INSTRUCTIONS	MB	07.09.28
B	D3256-3 DIM 1.30 WAS 0.65	RF	05.06.27
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3256 TITLE ACCESS PANEL SCALE NTS COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	3		
CHECKED	3		
MFG. APPR.	3		
APPROVED	3		
DE APPR.	3		
DATE	12.10.16		

8 7 6 5 4 3 2 1

D

D

C

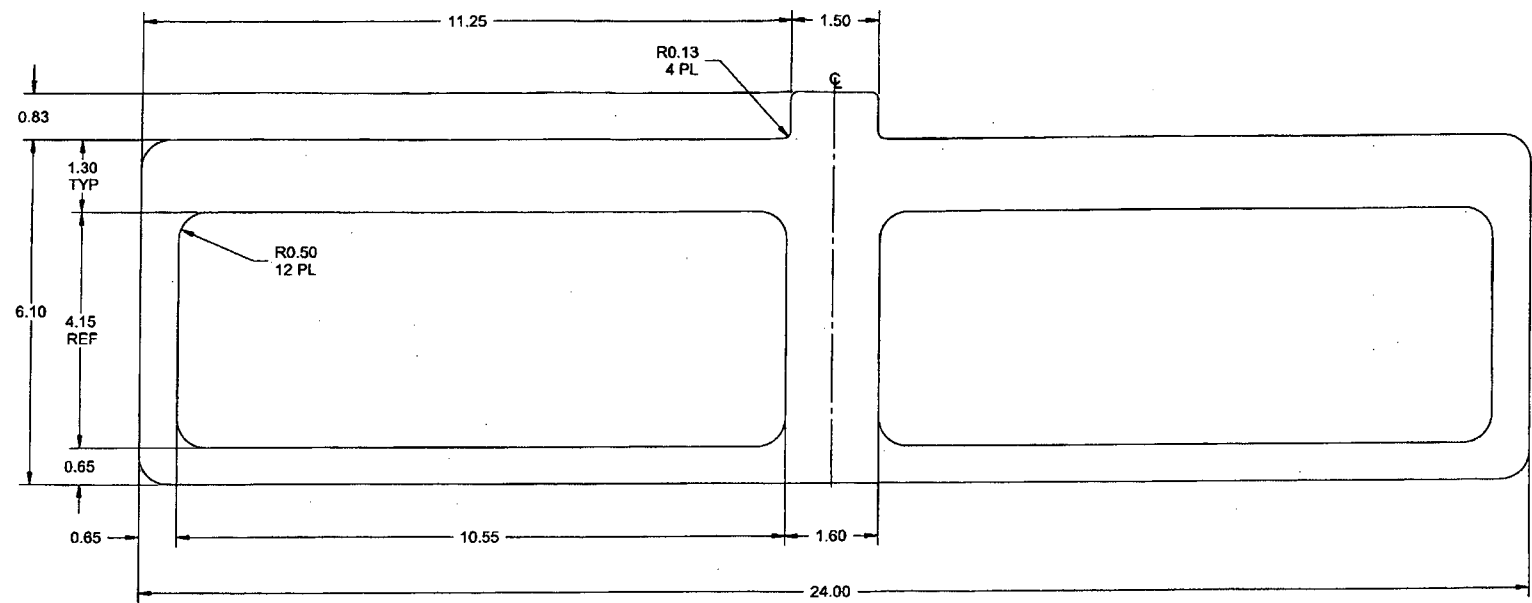
C

B

B

A

A



D3256-3 GASKET

RELEASED
2012-11-06

NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89; 0.060 THICK
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3256	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL	NTS
DATE	12.10.16	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1